



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4092-1
Job Sheet 185835



Part No: D4092-1

Job Qty: 20 pcs

Part Name: Maintenance Step



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C lpp Rev:A New Issue 10-05-31 JLM Verified By:DD IPP REV:B AS PER ECN 11-639 JLM
VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		11/23/18	0.00	1.14	Bandsaw - 1		DD 19-02-23
110	HAAS 4 Axis - B4B	20 pcs		11/23/18	0.27	18.18	HAAS - 1 - B4B		DJP 19-02-24
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	20 pcs		11/23/18	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		DJP 19-02-24
							QC 2 - 54		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S153228



Part: D4092-1

Job No: 185835

Serial No/Batch: S153228

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/13/19

D4092-1

C

S153228

130 QC 8	20 pcs	11/23/18	0.00 0.00	QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	df 19-02-25
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
140 Handfinish - 1-1 Chemical-B4B	20 pcs	11/23/18	0.00 2.21	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	D.R 19/2/25
155 Handfinish - 3-1- WingWalk-B4B	20 pcs	11/23/18	0.00 2.21	Handfinish - 3 - 1 - B4B	yl 19-2-27
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
160 QC 3	20 pcs	11/23/18	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	MAR 01 2019 68
				QC 3 - 9	9-89

170 Packaging 3-1 - Stock - B4B

20
pcs

11/23/18 0.00 0.00

Packaging 3 - 1 -
B4BPackaging 3 - 2 -
B4BPackaging 3 - 3 -
B4BPackaging 3 - 4 -
B4BPackaging 3 - 5 -
B4BPackaging 3 - 6 -
B4BPackaging 3 - 7 -
B4BPackaging 3 - 8 -
B4BPackaging 3 - 9 -
B4BPackaging 3 - 10 -
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B4BPackaging 3 - 28 -
B4BPackaging 3 - 29 -
B4BPackaging 3 - 30 -
B4BPackaging 3 - 31 -
B4BPackaging 3 - 32 -
B4B

Packaging 3 - 33 -

MAR 04 2019

57450

				B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
180	QC 21 - SA	20 pcs	11/23/18	0.00	0.00	QC 21 - SA - 21 QC 21 - SA - 70
Part Op 100 - Bandsaw1 (Bandsaw) Descriptions: 110 - HAAS1-4 (HAAS CNC Vertical Machine) Mill as per Dwg and Folio FA935 ****Grind flush transition machining mark after machining bottom of extrusion, see detail A.**** 120 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB) 130 - QC8 Machining-2 (QC8- Inspect parts - second check) 140 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1) 155 - HandFinish3 (Wing Walk as per dwg QSI005 4.4 Batch _____) 160 - QC3 (QC3- Inspect Part Finish) 170 - Packaging3-2 (Identify as per dwg & Stock Location: _____) 180 - QC21 (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D2761-108	Extrusion (HPK)	50 ft (2.5 ea)	100-Bandsaw - 1	B140540		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Bandsaw - 1	D2761-108	50	741	0		
Part Specifications						
Specifications could not be found.						

Plex 1/22/19 12:46 PM Dart.Hadley.Shannon

MAT
used
50.82
SCRAP
9.890



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					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Machining-2		
100	Bandsaw	20 pcs	11/23/18	11/23/18	0.00	1.14	Bandsaw1		
110	CNC Vertical Machining	20 pcs	11/23/18	11/23/18	0.27	18.18	HAAS1-4		
120	QC	20 pcs	11/23/18	11/23/18	0.00	0.00	QC2 Machining-2		
130	QC	20 pcs	11/23/18	11/23/18	0.00	0.00	QC8 Machining-2		
140	HandFinish	20 pcs	11/23/18	11/23/18	0.00	2.21	HandFinish1		
155	HandFinish	20 pcs	11/23/18	11/23/18	0.00	2.21	HandFinish3		
160	QC	20 pcs	11/23/18	11/23/18	0.00	0.00	QC3		
170	Packaging	20 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-2		
180	QC21-SA	20 Ea	11/23/18	11/23/18	0.00	0.00	QC21		

Part Op 110 - Mill as per Dwg and Folio FA935 ****Grind flush transition machining mark after machining bottom of extrusion, see
Descriptions: detail A.****

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2761-108	Extrusion (HPK)	50 ft (2.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2761-108	50	910	0

Part Specifications

Specifications could not be found.

141

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
<table style="width: 100%; border: none;"> <tr> <td style="width: 25%; vertical-align: top;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 25%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width: 25%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 25%; vertical-align: top;"> FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width: 25%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width: 25%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>					Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
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OTHER : _____																					

